

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024024**Date Inspected:** 09-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #16

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint- 003, Located on Bike path Hand rails, FS2-PP53. Welder is identified as 201861. ZPMC Quality Control Inspector (QC) is identified as Gao Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) -Repair.

Repair welding of Weld joint- 001, Located on Bike path Hand rails, FS3. Welder is identified as 201905. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) -Repair.

Bay #14

This QA Inspector observed the following work in progress

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Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint- 001 as per WRR no. B-WR-20922, Located on U Rib Splice plate X3305K-056. Welder is identified as 200569. ZPMC Quality Control Inspector (QC) is identified as Li Yan Hua. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair.

Repair welding of Weld joint- 002 as per WRR no. B-WR-20884, Located on U Rib Splice plate X3305K-090. Welder is identified as 067752. ZPMC Quality Control Inspector (QC) is identified as Li Yan Hua. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair.

Witness of Magnetic Particle Testing (MT)

This QA inspector Witnessed 100% MT performed by ZPMC Quality Control personnel. The member is identified as U Rib Splice plate -OBG Component. The component and weld designation identified as follows:

X3305K-062-001, 002

X3305K-089-001, 002

X3305K-075-001, 002

Bay #19

This QA Inspector observed the following work in progress,

Flux Cored Arc Welding (FCAW)

Repair welding of Weld joint- 023 as per WRR no. B-WR-20944, Located on Cable Bracket components SA6029-001. Welder is identified as 062757. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F)-Repair.

Repair welding of Weld joint- 061 as per WRR no. B-WR-20945, Located on Cable Bracket components SA6030-001. Welder is identified as 062783. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F)-Repair.

Repair welding of Weld joint- 070/ 071 as per WRR no. B-WR-20943, Located on Cable Bracket components SA6530-001. Welder is identified as 062739. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F)-Repair.

Weld joint- 045/ 046, Located on OBG Bike path components BK23A-001. Welder is identified as 208634. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2134-ESAB.

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For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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